

Work Order ID 117306

\*117306\*

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October-01-14 9:23:32 AM

Item ID: 647.9501 Accept \*N9000040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Quick Release Pin Assembly  
 Start Date: 6/13/14 Start Qty: 100.00 \*100\* 28X Cust Item ID:  
 Required Date: 6/20/14 Req'd Qty: 100.00 \*100\* Customer:  
 Reference: NCR14-3950 - Rework

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
647.9500	N/C								

110

0.00

\*110\*

Small Fab

Small Fab

Memo

0.00

PULL FROM STK:  
 60 X 647.9501 B92907 ✓  
 30 X 647.9501 B92919 ✓  
 10 X 647.9501 B93349 ✓  
 REMOVE PIP PIN (601.3202) DISCARD  
 REPLACE WITH CORRECT PIP PINS  
 601.3202 (92851A115) B 129968  
 PER NCR14-3950

100X

DAS  
28  
9-89

NOV 11 2014

- 1- CUT AND STRIP CABLE AS PER DWG
- 2- REMOVE SNAP RING ON QUICK PIN BEFORE ASSEMBLING.
- 3- ASSEMBLE SLEEVE, PIN AND GROUND PLATE AS PER DWG

Work Order ID 117306

\*117306\*

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October-01-14 9:23:32 AM

Item ID: 647.9501 Accept \*N900040100\* Setup Start \*NS1\*  
Revision ID: Stop \*NS2\*  
Item Name: Quick Release Pin Assembly  
Start Date: 6/13/14 Start Qty: 100.00 \*100\* Cust Item ID:  
Required Date: 6/20/14 Req'd Qty: 100.00 \*100\* Customer:  
Reference: NCR14-3950

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC5- Inspect part completeness to step on W/O	0.00							DAS 38 9-89
*120*						(28)			
QC	Memo	0.00							
Quality Control									

NOV 11 2014

130	Identify as per dwg & Stock Location. <u>CC1C 120</u>	0.00
*130*		
Packaging	Memo	0.00
Packaging	RE-IDENTIFY USING NEW B/N	

28  
DAS  
08  
9-89

NOV 11 2014

140	QC21- Final Inspection - Work Order Release	0.00
*140*		
QC	Memo	0.00
Quality Control		

14/11/12

14-11-11

# Picklist Print

October-01-14 9:23:31 AM

Page 1

Work Order ID: 117306

**\*117306\***

Parent Item: 647.9501

**\*647 9501\***

Parent Item Name: Quick Release Pin Assembly

Start Date: 6/13/14

Required Date: 6/20/14

Start Qty: 100.00

Required Qty: 100.00

Comments: IPP REV:A 12.12.23 NEW ISSUE DD VERF:jlm

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
601.3202		Purchased			No		Each	14.0000		100			
<b>*601 3202*</b>									**			DAS 28 9-89	NOV 11 2014
Quick Release Pin													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				cck100				14		129968 X25			
				105197				11					
				m129311				3		3X			
647.9501		Manufactured			No		Each	0.0000		100			
<b>*647 9501*</b>									**				
Quick Release Pin Assembly													

B 93349 X 8

B 92919 X ~~20~~ ~~20~~ ~~20~~  
X20

APICAL INDUSTRIES, INC.	ENGINEERING CHANGE NOTICE NO. 03689				SHEET 1 OF 1	
	DWG NO. 647.9500	REV: N/C	PREPARED BY B. PETERS	DATE: 11/12/12	EFFECT ON DWG <input type="checkbox"/> INC. <input checked="" type="checkbox"/> UNINC.	
	DWG TITLE: QUICK RELEASE PIN ASSY					
APPROVED BY: ENGR <i>[Signature]</i>		MFG. <i>[Signature]</i>	QC <i>[Signature]</i>	EFFECT NEXT ORDER		
TRANSACTION CODES (TC) A-ADD C-CREATE R-REVISE D-DELETE		REASON: ADDED ALTERNATE MATERIAL AND ALTERNATE PARTS.				ECR: D-12-021

**IS** →

NOTES

⚠️ SNAP RING REMOVED DURING ASSEMBLY.

⚠️ PRIMARY MATERIAL: 303 STAINLESS STEEL JAW AMS 5643, 1/2H, .09" THK, FINISH NONE.  
ALTERNATE MATERIAL: 304 STAINLESS STEEL JAW AMS 5513, 1/2H, .09" THK, FINISH NONE.

⚠️ SWAGE USING NICO PRESS MLI-SC HAND SWAGER. SWAGE UNTIL JAWS ARE COMPLETELY CLOSED.

⚠️ ALTERNATE P/N 60L3590

⚠️ ALTERNATE P/N 60L3589

**SHEET 1, ZONE A2 WAS:**

*WLO 117306*

4	R	601.1054	2		SWAGING SLEEVE		⚠️ 3 ⚠️ 5
3	R	601.1581	.75 FT		CABLE		⚠️ 4
F/N	TC	PART NUMBER	QTY		DESCRIPTION	MATERIAL	SPECIFICATION
DOCUMENTS EFFECTED:					CHANGE CATEGORY		DER REVIEW REQUIRED
<input type="checkbox"/> RFMS <input type="checkbox"/> MDL <input type="checkbox"/> INSTALL INSTRU <input type="checkbox"/> ICA <input checked="" type="checkbox"/> BOM					<input type="checkbox"/> MAJOR <input checked="" type="checkbox"/> MINOR		<input type="checkbox"/> YES <input checked="" type="checkbox"/> NO

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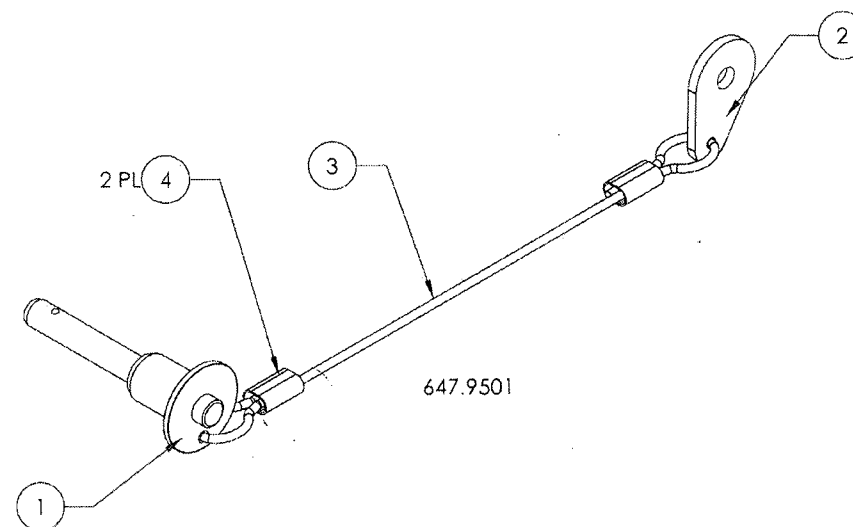
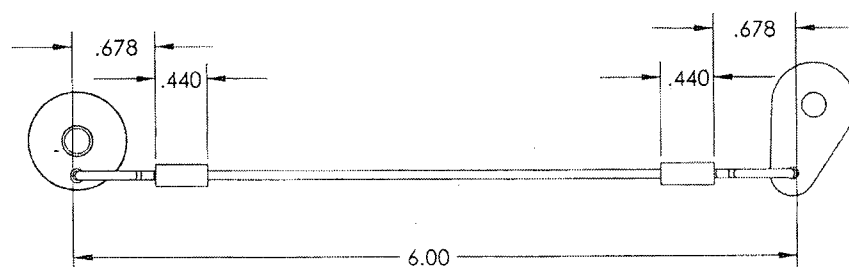
REVISIONS		
REV.	DESCRIPTION	DATE
N/C	LAST PROTOTYPE RELEASE: P81	
	INITIAL RELEASE	04-21-10
		P. BRAVO

# NOTES:

1. SNAP RING REMOVED DURING ASSEMBLY.
2. MATERIAL: 303 STAINLESS STEEL IAW AMS 5643, 1/2H; .09" THK. FINISH: NONE.
3. SWAGE USING NICOPRESS NO.1-SC HAND SWAGER. SWAGE UNTIL JAWS ARE COMPLETELY CLOSED.

UNINCORPORATED ECN(s)

031e89



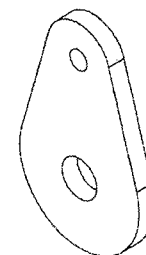
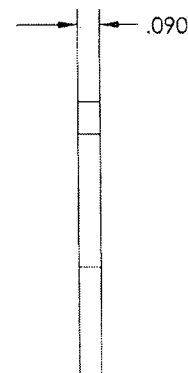
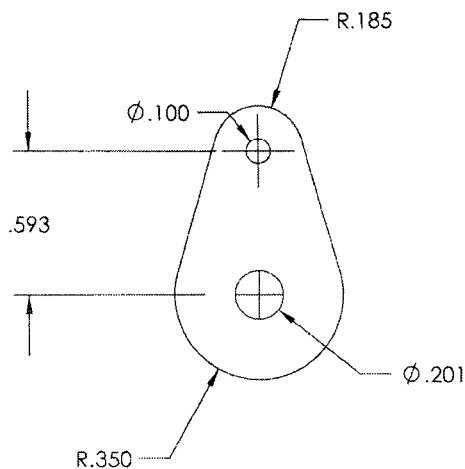
QTY	FIND #	PART #	DESCRIPTION	MAT'L	SPEC.
2	4	601.1054	SWAGING SLEEVE		△
.75	3	601.1581	CABLE		
1	2	647.9511	GROUND PLATE	△	
1	1	601.3702	QUICK RELEASE PIN		△
1		647.9501	QUICK RELEASE PIN ASSY		
9501	FIND #	PART #	DESCRIPTION	MAT'L	SPEC.
QTY	PARTS LIST				
NEXT ASSY (\$)	ORIGINAL DATE				
647.8900	B. ROSANO P. BRAVO				
647.9400	DRAWING APPROVAL				
	UNLESS OTHERWISE SPECIFIED				
	DIMENSIONS ARE IN INCHES				
	TOLERANCES ARE				
	FRACTIONS DECIMALS ± .01				
	3 PLACE DECIMALS ± .001				
	ANGLES ± .001				
	301	CHG CODE	DWG NO	647.9500	N/C
	B	07M26			
	SCALE	NONE			
					SHEET 1 OF 2

APICAL INDUSTRIES  
2608 TEMPLE HEIGHTS DR.  
OCEANSIDE, CA. 92056-3512 (760) 724-5300

QUICK RELEASE PIN ASSY

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REVISIONS			
REV	DESCRIPTION	DATE	APPROVED



647.9511

ORIGINAL DATE 11/03/04-171 00-21-10		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWN BY P. BORLAND	CHECKED P. BRAVO	QUICK RELEASE PIN ASSY	
DRAWING APPROVAL P. BRAVO		SCALE: NONE	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS $\pm .01$ 3 PLACE DECIMALS $\pm .005$ ANGLES $\pm .5^\circ$		SPE B	REV N/C
CASE CODE 07M26	CWG. NO. 647.9500	SHEET 2 OF 2	

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only

Work Order: <u>117306</u> Part No. <u>647.9501</u> NCR No. _____	<b>DISPOSITION</b> Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>
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[illegible]

### FAULT CATEGORY

Landing Gear	General			
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Folio/Program	<input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Pressure/Forced
<input type="checkbox"/> Centre Not Concentric	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Grain	<input type="checkbox"/> Over/Under tolerance	<input type="checkbox"/> Set-up
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damage/Defect	<input type="checkbox"/> Hardware	<input type="checkbox"/> Part Incorrect	<input type="checkbox"/> Temperature/Cure
<input type="checkbox"/> Crimp/Kink/Ripple/Wave	<input type="checkbox"/> Burrs	<input type="checkbox"/> Inspection Incomplete/Unqualified	<input type="checkbox"/> Part Lost/Missing	<input type="checkbox"/> Weld
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Instructions Incomplete/Unclear	<input type="checkbox"/> Part Moved	<input type="checkbox"/> Wrong Stock Pulled
<input type="checkbox"/> Crushing	<input type="checkbox"/> Countersink	<input type="checkbox"/> Misaligned/off center	<input type="checkbox"/> Positioned Wrong	<input type="checkbox"/> Other
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Mislabeled	<input type="checkbox"/> Power Loss/Surge	
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Drawing	<input type="checkbox"/> Misread		
<input type="checkbox"/> Marks/Chatter	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Off-set		
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Calibration		
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Fit/Function	<input type="checkbox"/> Out of Sequence		